

Work Order ID 75340

75340

Page 1

October-21-11 7:57:50 AM

Item ID: D350-591-213

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, Short LH

Stop ***NS2***

Start Date: 20/10/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 11/10/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

8/2/2013

MLJ 12-1-30 (4)

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

AL 1/12 12.01.22

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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 Start Date: 20/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00	Cpl 12-01-23			4x	Ø		
130 *130* Large Fab Large Fab	Large Fab Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R Aluminum Rod 114514 3-Grind End Plate flush 117912	0.00 0.00	12-01-23			4	Ø		
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	BE 12-01-24			4	Ø		

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		512/01/24		(x4) LH			
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							H BR 12-1-24.
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							464 ϕ 14 12/01/25 counted - measured

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
	1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod <u>114514</u> 5-Grind End Plate flush								
210 *210* QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
220 *220* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

230

HandFinish

Hand Finishing

Memo

0.00

Handwritten: 4 BX 12-1-30

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

240

Powdercoat

Powder Coating

Memo

0.00

START TIME: *11:00*

OVEN TEMPERATURE: *320 OF*

FINISH TIME: *11:30*

Handwritten: 4X Ø M-L 12/01/30

250	Wing Walk as per dwg QSI005 4.4 Batch <i>12025</i>	0.00							
-----	--	------	--	--	--	--	--	--	--

250

HandFinish

Hand Finishing

Memo

0.00

Handwritten: 4 BX 12-1-31

Handwritten: m11a480

W/O:		WORK ORDER CHANGES					
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N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

260 QC3- Inspect Part Finish

0.00

260

QC Memo

0.00

Quality Control

4th of Jul 12/01/31
COUNT & MEASURED

270 Pick Kit

0.00

270

Packaging Memo

0.00

Packaging

02/02/3

280 QC4- 100% Inspect kits for completeness

0.00

280

QC Memo

0.00

Quality Control

8.7/02/03

[Signature]

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	Packaging	0.00							
290									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-213								
	Location: _____								
	PPP Rev: _____								
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

(H) SP12-02-03

12/2/6 48

012-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 75340

75340

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:B05.10.14Modified step 10KJ/EC

IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM

IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D

10.03.17 incorporate seq 180 to 200 remove qc5 DD verified

by:JLM

IPP Rev:E

10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

110

Each

108.1200

0.5

2

D2622-120C

**

Ac 12.01.20

Step Extrusion

Location

Loc Qty

Loc Code

HALL

98.42

64409

6

68293

0.5

72131

91.92

WA

9.7

46910

2

66970

7.7

875781 (x2)

D3067-1

Manufactured

No

130

Each

63.0000

1

4

D3067-1

**

12.01.23

End Plate

Location

Loc Qty

Loc Code

WA

B78022

62

67582

2

73404

60

WA016

1

68214

1

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 2

Work Order ID: 75340

75340

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3063-1 Manufactured No

130 Each 78.0000 1 4

D3063-1

Support

**

12.01.23

Location Loc Qty Loc Code

WA 78

66182 18

71886 60

MS20600-AD4W4 Purchased No

180 Each 2,694.000 16 64

MS20600-AD4W4

Rivets

**

12.01.26

Location Loc Qty Loc Code

ST321 2689

116188 59

117364 253

117601 200

117885 195

118840 1982

WA018 5

116712 5

D3066-1 Manufactured No

180 Each 48.0000 2 8

D3066-1

Spacer

B 76180 = 6 B 77564 = 2 **

12.01.26

Location Loc Qty Loc Code

WA 48

73409 48

D3065-041 Manufactured No

180 Each 0.0000 1 4

D3065-041

Step Leg Assembly Hi

**

12.01.26

B 77054 = 2
B 78797 = 2

October-21-11 7:57:56 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 75340

75340

Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3067-1 Manufactured No

200

Each

63.0000

1

4

D3067-1

End Plate

**

12.01.26

Location

Loc Qty

Loc Code

WA 378022 62

67582 2

73404 60

WA016 1

68214 1

4

AN3-35A Purchased No

270

Each

99.0000

2

8

AN3-35A

Bolt

**

3x
M119443 *M120182*

Location

Loc Qty

Loc Code

ST353 99

117619 3

117794 1

118838 95

D2856-400 Manufactured No

270

f

334.8845

0.6

2.4

D2856-400

Abraison Strip

**

2.4
12/1/30

Location

Loc Qty

Loc Code

ST403 0.3149

68076 0.3149

ST409 334.5696

63735 0.6696

71164 117.9

73491 216

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

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Shop Packet Print

Page 3

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Parent Item: D350-591-213

D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-11A Purchased No

270 Each 264.0000 2

AN4-11A

Bolt

**

Location

Loc Qty

Loc Code

ST356

264

110382

1

115316

63

117872

100

118706

100

AN960JD416 , NAS1149D0463J Purchased No

270 Each 0.0000 12

AN960JD416

Washer

**

D2230-1 Manufactured No

270 Each 277.0000 2

D2230-1

Lug

**

Location

Loc Qty

Loc Code

ST470

100

72811

100

ST476

177

67826

6

69821

11

70974

20

73398

140

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step, Short LH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

270

Each

9,976.000

2

8

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

ST300

976

117441

16

117885

87

118451

179

118927

694

ST516

6000

119017

6000

ST518

3000

119075

3000

AN4-13A

Purchased

No

270

Each

1,136.000

4

16

AN4-13A

**

Bolt

Location

Loc Qty

Loc Code

ST357

1136

118078

590

118706

46

118838

500

D2732

Manufactured

No

270

f

553.8700

1

4.210826

D2732

**

Rubber Extrusion

Location

Loc Qty

Loc Code

ST

5

64283

5

ST410

548.87

70987

498.87

73759

50

cut qty of 4 at 3.00" as per dwg(D2732-030)

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D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

D2230-3

Manufactured No

270

Each

183.0000

2

8

D2230-3

Lug

**

BT 15612

Location

Loc Qty

Loc Code

ST476

4

53881

4

ST480

179

70973

1

73396

178

AN960JD10.

NAS1149D0363J

Purchased

No

270

Each

0.0000

4

16

AN960JD10

Washer

**

M1201428

MS21042L4

Purchased

No

270

Each

13,961.00

6

24

MS21042L4

Nut

**

12/1/30 SL (4)

Location

Loc Qty

Loc Code

ST300

2961

117441

51

117601

537

118451

1373

118927

1000

ST516

6000

119017

6000

ST518

5000

119075

5000

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-16A

Purchased

No

270

Each

132.0000

4

16

AN4-16A

Bolt

**

12/1/30 J/K

Location

Loc Qty

Loc Code

ST358

132

117872

82

118838

50

6
10

W/O:		WORK ORDER CHANGES					
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

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WORK ORDER

NO. 75340 M.C.J
11/10/21

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: [Signature]
D. SHEPHERD (DE # 02)
DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>92</u>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>4</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>N/A</u>	DSI 9472	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

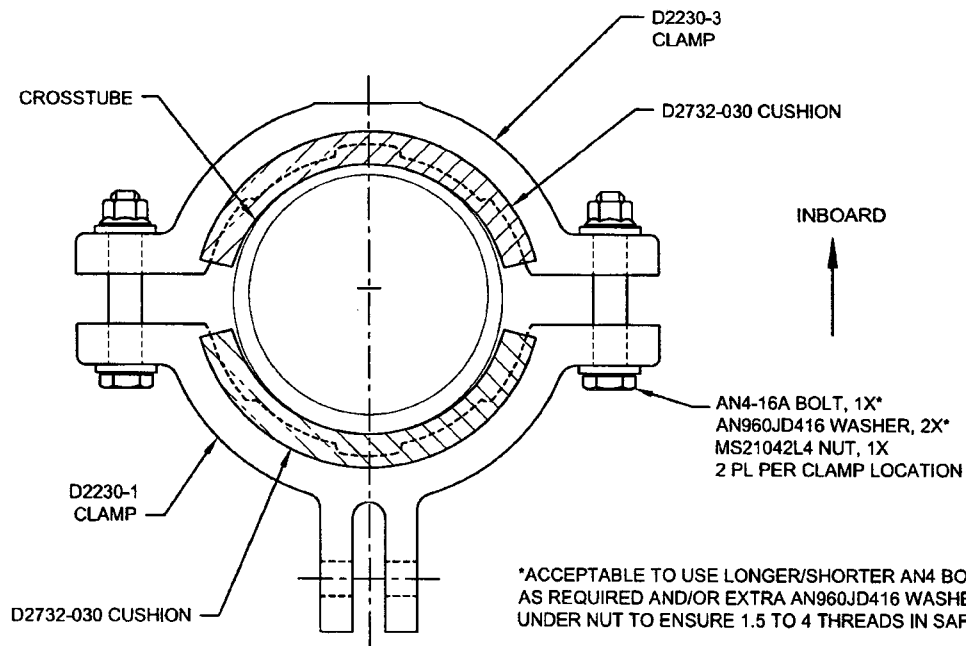


FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
APPROVED	WJ	TITLE	SCALE
DE APPR.	TH	BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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95340

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

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NO. 75340 M.C.5
12/01/13

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

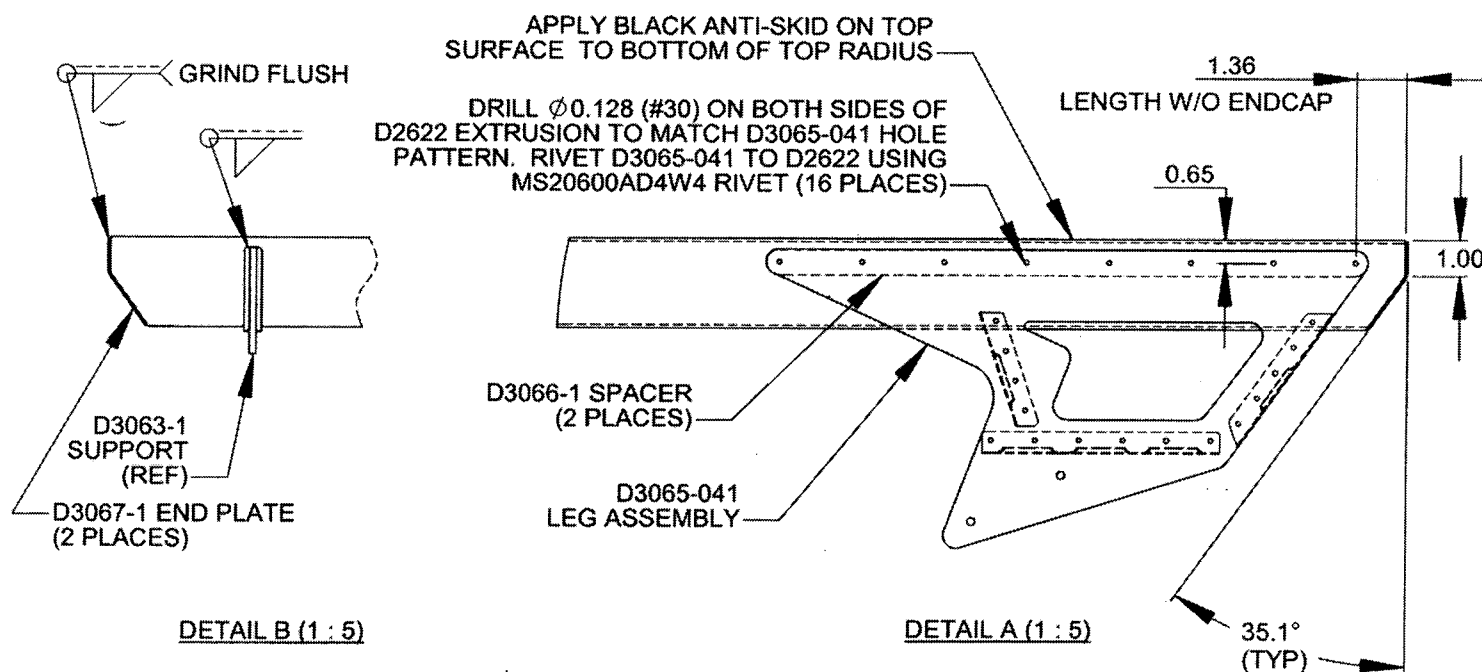
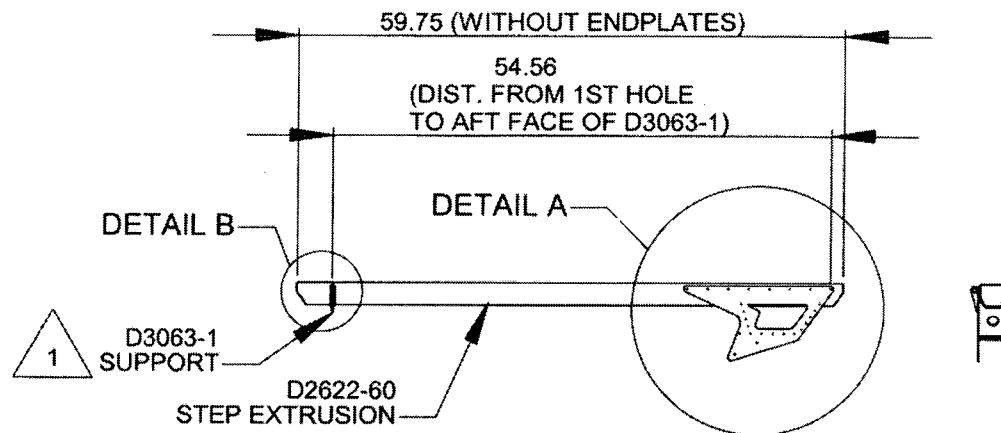
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02.09.2004

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CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3078	SHEET 2 OF 2
02.09.11		TITLE	SCALE
		STEP ASSEMBLY, HI SHORT	1:20



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
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

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	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

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DESIGN	92	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
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